

Work Order ID 80863

Thursday, March 01, 2012 3:55:02 PM

80863

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 3/1/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: *P* Date: *DB-1*

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3804	A
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IIN-D206-642	O
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

NA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R Aluminum Rod <u>M120164</u>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

> 1 0 12-3-5

SAD 12-03-05

SAD 12-03-06

SAD 12-03-07

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160									
Skidtubes	Skidtubes	0.00							
Skidtubes	Memo								
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

180

Skidtubes

0.00

180

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 12-03-08 Time: 10h30Finish Date: 12-03-12 Time: 11-30

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 M120813Sikaflex expire date: 2013-08-1312-3-8SAO12-03-08

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Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			<u>1</u>	<u>0</u>	<u>8512/23/12</u>	

W/O:		WORK ORDER CHANGES					
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Reference:

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch
A/RAluminum Rod 12/20/14

3-Grind welds flush as per Dwg D3804.

SAD 12-03-12

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 12/03/12
12-3-15

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00

210

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804



12-3-15

215

0.00

215

QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

Pc 12.03.15

1x 6

220

0.00

220

QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8.2/3/15

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

8/17/15

Quality Control

240

Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

IX of M / 12/03/17

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M 120202

2:05
2:35

1 BL 12-3-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

1 X M-1 12/23/21

270

HandFinishing

0.00

270

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 BR123-21

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	HandFinishing	0.00							
280	HandFinish	0.00							
Hand Finishing	Memo 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>119994</u> Sikaflex expire date: <u>12-8</u> 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>119094</u>								
290	QC3- Inspect Part Finish	0.00							
290	QC	0.00							
Quality Control	Memo								

M-L / BR 12321.

12 03 220

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310		0.00							
310	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

12/03/30

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	30.0000	1	1			
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D2620

Skidtube, 206 Skidtube

**

CF 12-3-5

Location

Loc Qty

Loc Code

LG

30

77996

1

77999

10

78000

5

79542

1

79543

2

79544

8

79545

3

①

D2647		Manufactured	No			110	Each	63.0000	1	1			
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D2647

Cap

**

BE 12/03/05

Location

Loc Qty

Loc Code

LG002

63

75482

63

F

W/O:		WORK ORDER CHANGES					
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Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

7,334.000

52

52

CR3212-4-04

Cherry Rivet

**

SAD 12-03-08

Location

Loc Qty

Loc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

7166

119075

7166

52

D2654-1

Manufactured

No

180

Each

17.0000

1

1

D2654-1

Web

**

SAD 12-03-08

Location

Loc Qty

Loc Code

LG

17

79540

5

79541

10

80054

2

B80055

121.0000

2

2

D3286-1

Manufactured

No

180

Each

121.0000

2

2

D3286-1

Doubler

**

SAD 12-03-08

Location

Loc Qty

Loc Code

LG002

217

74872

6

78014

93

ST046

-96

76772

22

(2)

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Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 1,831.000 19 19

D2649

Cross Bolt Spacer

*******BE 12/03/12*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	1374	
----	------	--

77574	2	
-------	---	--

79502	403	
-------	-----	--

79503	399	
-------	-----	--

79504	309	
-------	-----	--

79565	261	
-------	-----	--

LG001	457	
-------	-----	--

65317	1	
-------	---	--

68224	2	
-------	---	--

68507	11	
-------	----	--

71355	2	
-------	---	--

72704	2	
-------	---	--

72841	11	
-------	----	--

73390	8	
-------	---	--

73857	21	
-------	----	--

73858	53	
-------	----	--

73859	4	
-------	---	--

73860	4	
-------	---	--

78020	6	
-------	---	--

78583	2	
-------	---	--

79566	330	
-------	-----	--

D3286-3 Manufactured No 200 Each 125.0000 2 2

D3286-3

Spacer

*******BE 12/03/14*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

LG	15	
----	----	--

78015	15	
-------	----	--

LG001	110	
-------	-----	--

74117	1	
-------	---	--

79557	109	
-------	-----	--

Thursday, March 01, 2012 3:55:06 PM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

Thursday, March 01, 2012 3:55:06 PM

Work Order ID: 80863

80863

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each

171.0000 1

D2680-041

Nut Plate

**

DP 12-3-15

Location Loc Qty Loc Code

ST013 116

78016 116

ST019 55

76790 55

CR3212-4-03 Purchased No

210 Each

1,512.000 2

CR3212-4-03

Cherry Rivet

**

DP 12-3-15

Location Loc Qty Loc Code

FP002 522

114859 522

ST331 990

110139 2

119017 988

AN960JD416 ~~ANAS1149D0463J~~ Purchased No

210 Each

24.0000 1

AN960JD416

Washer

**

DP 12-3-21

Location Loc Qty Loc Code

ST351 24

116289 24

CCR264SS3-3 Purchased No

210 Each

767.0000 2

CCR264SS3-3

Cherry Rivet

**

DP 12-3-15

Location Loc Qty Loc Code

ST331 767

113973 2

117849 129

119017 636

Thursday, March 01, 2012 3:55:06 PM

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Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, March 01, 2012 3:55:06 PM

Page 5

Work Order ID: 80863

80863

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

212.0000

1

1

MS27039-4-06

Screw

**

BR 12-3-21

Location

Loc Qty

Loc Code

ST292

212

119075 ✓

212

1

D2651-1

Manufactured

No

270

Each

749.0000

6

6

D2651-1

Plug

**

BR 12-3-21

Location

Loc Qty

Loc Code

FP001

884

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584 ✓

245

79234

278

6

FP-A

-135

77559

1

78124

164

D2651-3

Manufactured

No

270

Each

2,065.000

6

6

D2651-3

O-Ring

**

BR 12-3-21

Location

Loc Qty

Loc Code

FP001

137

61962

12

73828

125

FP-A

1928

78126 ✓

1928

5

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

Thursday, March 01, 2012 3:55:06 PM

Work Order ID: 80863

80863

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No 280 Each 129.0000 14 14

D3873-1

Bushing

**

BL 12-3-21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST067 <i>74561</i>	129	<i>121</i>
64760	1	
68247	4	
73829	19	
73830	2	
79560	103	

D2646 Manufactured No 280 Each 60.0000 1 1

D2646

Aft Cap

**

BL 12-3-21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002 <i>79500</i>	60	<i>1</i>
62678	5	
68280	5	
70945	1	
71070	2	
73294	1	
73825	2	
78018	44	

D3805-041 Manufactured No 280 Each 6.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

BL 12-3-21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001 <i>78005</i>	1	<i>1</i>
76779	1	
FP002	5	
78002	5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Thursday, March 01, 2012 3:55:06 PM

Work Order ID: 80863

80863

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,259.000

2

2

MS27039-1-08

**

Screw

LocationLoc QtyLoc Code

ST291

1259

117423

81

119075 ✓

172

119109

6

120308

1000

MS21042L3

Purchased

No

280

Each

3,758.000

7

7

MS21042L3

**

Nut

LocationLoc QtyLoc Code

ST300

3758

117441

16

117885

32

118451

5

118927

3

119017 ✓

3505

119075

197

D3805-045

Manufactured

No

280

Each

12.0000

1

1

D3805-045

**

Wearplate Assembly Aft, Low Gear

LocationLoc QtyLoc Code

FP001

12

73817

1

74896

1

78010

10

AN960JD10L

XNAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

*AN960JD10L *

**

Washer

120644

2

BL 12.3.21

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 8

Thursday, March 01, 2012 3:55:06 PM

Work Order ID: 80863

80863

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280

Each

846.0000

7

7

AN3-37A

**

Bolt

Location

Loc Qty

Loc Code

ST353

846

117619

4

119086 /

842

NAS1149D0363J Purchased No

280

Each

2,337.000

7

7

NAS1149D0363.J

**

Washer

Location

Loc Qty

Loc Code

ST298

2337

117601

61

118077

1

118612

18

119537

309

120142 /

330

120308

618

120644

1000

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Page 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

80863-MLJ
12/03/02

RELEASED
09-03-03
per ECN 09-538

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	J		
CHECKED	0		
MFG. APPR.	E		
APPROVED	100		
DE APPR.	11		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

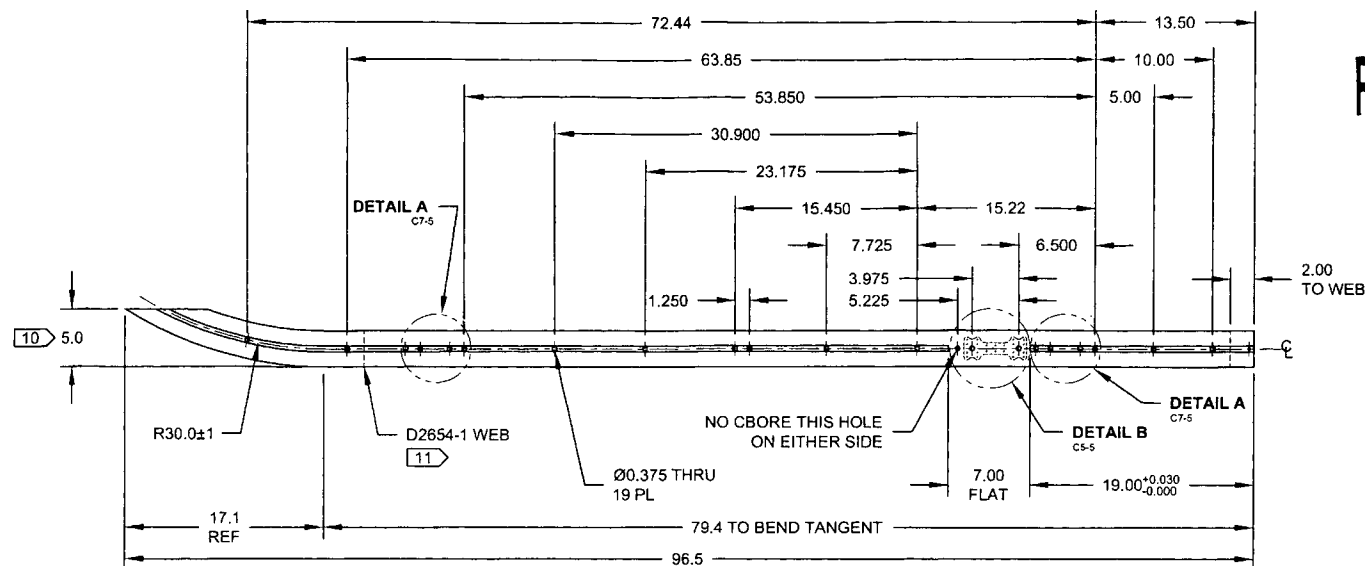
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

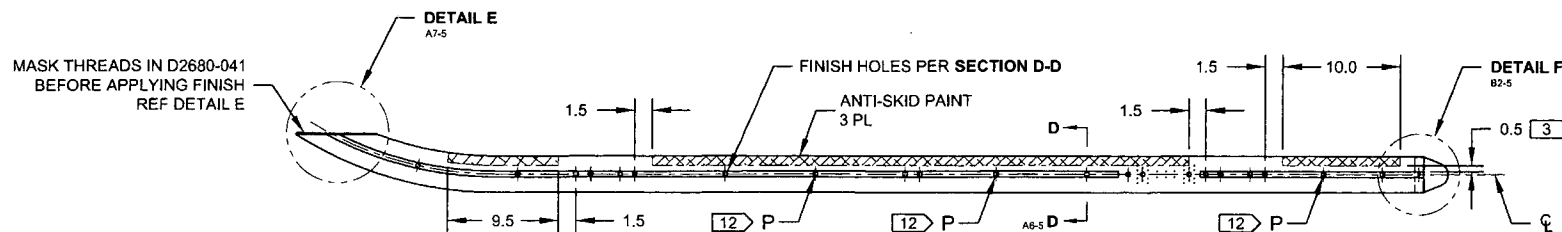
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RELEASED
09.03.03

80863



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 2 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

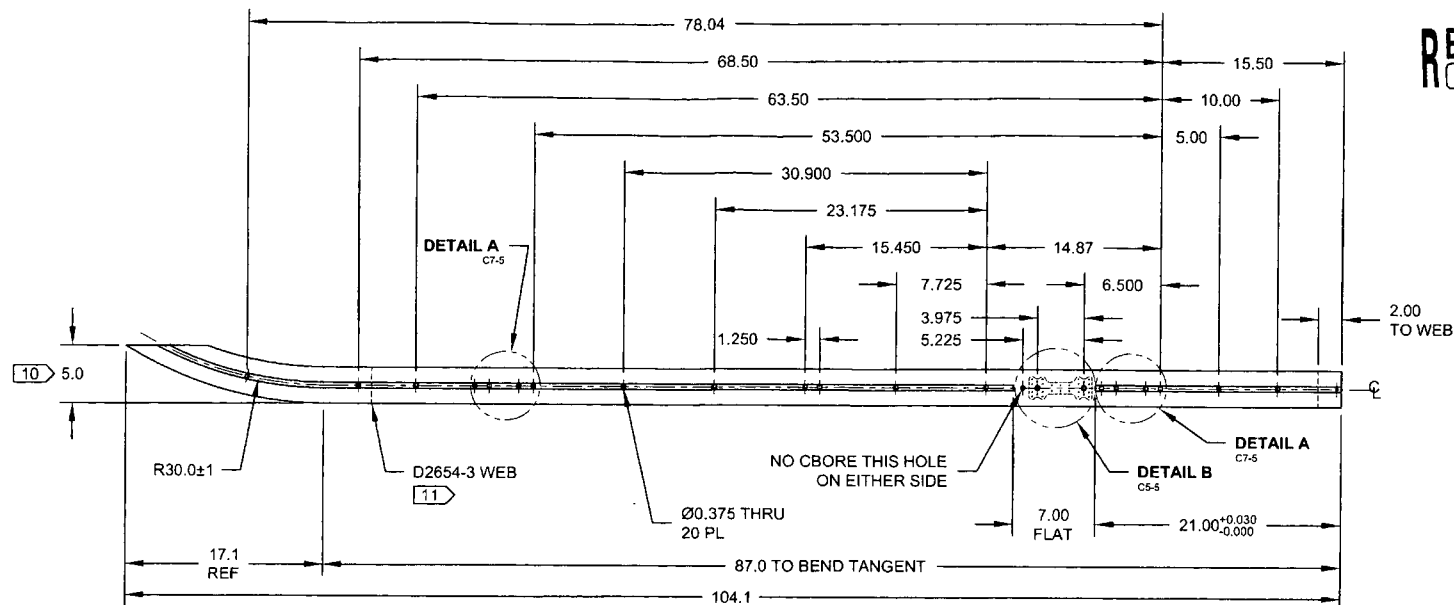
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

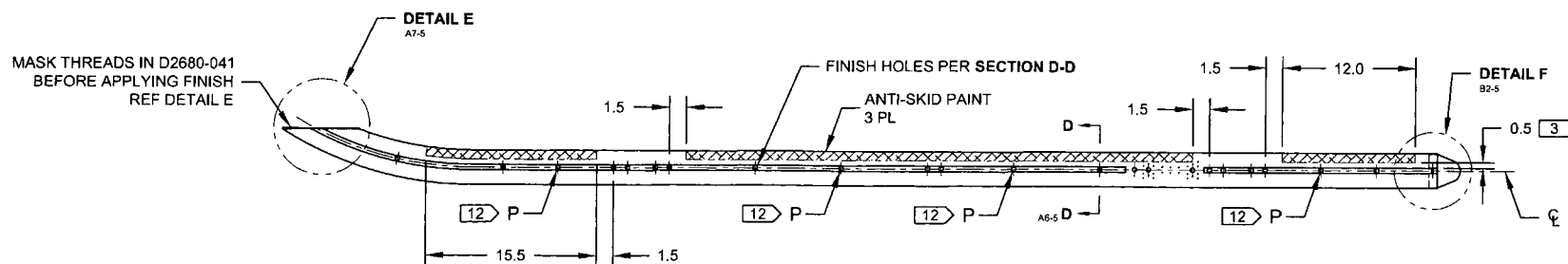
NOTE: Date & initial all entries

RELEASED
09-03-03

80863



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

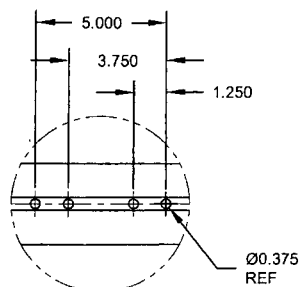
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

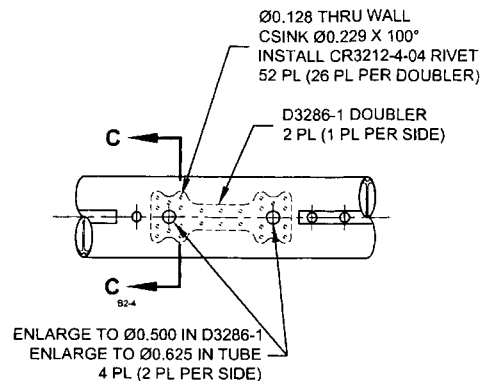
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

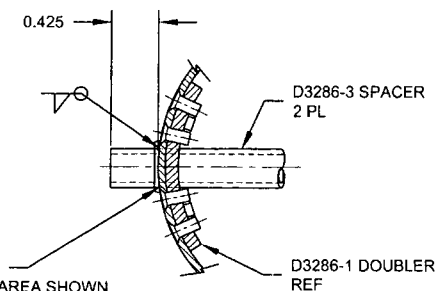
RELEASED
UP 09.03.03



DETAIL A D6-2
C2-2
D6-3
C2-3
SCALE NONE



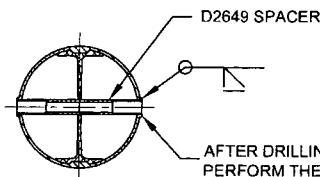
DETAIL B C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

80863

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	2	DRAWING NO.	REV. A
MFG. APPR.	3	D3804	SHEET 4 OF 5
APPROVED	4	TITLE	SCALE
DE APPR.	5	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

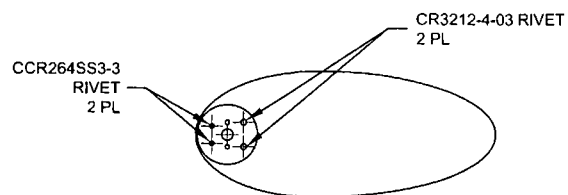
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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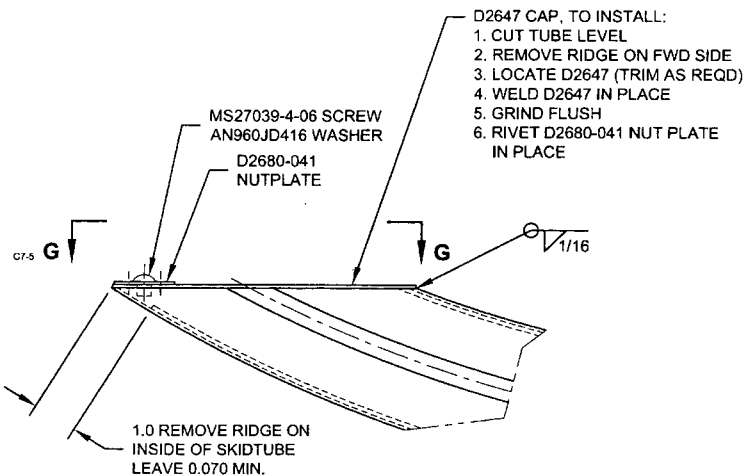
NOTE: Date & initial all entries

RELEASED
97 09 03 53

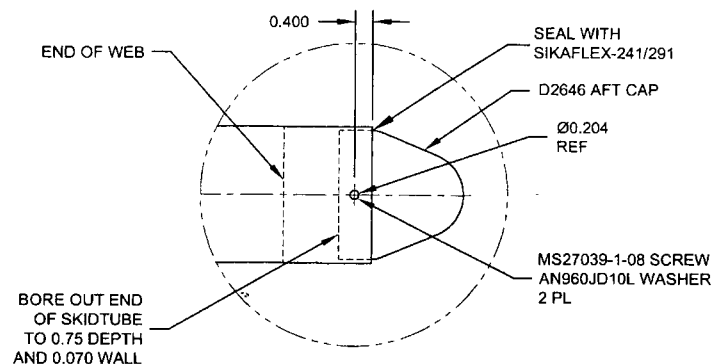
800603



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2
B7-3



DETAIL F
SCALE NONE B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 285

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 79322
Part number: A206-642-541
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier David Hunt Date of Test Coupon 18.03.14
Welder Barclay Elliott Date of Test Coupon 18.03.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld